

ASR

**\*107530\***

**Item ID:** D4434-047

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

**Revision ID:**

**Item Name:** Cover Assembly

Stop \*NS2\*

**Start Date:** 9/27/13      **Start Qty:** 8.00

\*3\* \*10\*

**Cust Item ID:**

**Required Date:** 10/04/13      **Req'd Qty:** 8.00

**Customer:**

**Reference:**

Approvals: Process Plan: MLS

Date: 13-09-27 Tooling:

Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_

**Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_

Date:

Stop \*NR2\*

[illegible]

# Work Order ID 107530

September-27-13 11:22:49 AM

**\*107530\***

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Item ID: D4434-047 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Cover Assembly  
 Start Date: 9/27/13 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 10/04/13 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 DAS 27 9-89 0.00 B.9.30				10			
130 <b>*130*</b> Brake NC Brake NC	Bend as per dwg  Memo	0.00 0.00		DAS 30 9-89		10			13/11/04
140 <b>*140*</b> Small Fab Small Fab	Transfer drill hole as per dwg Memo	0.00 0.00		DAS 30 9-89		10			13/11/04

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Item ID: D4434-047 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Cover Assembly  
 Start Date: 9/27/13 Start Qty: 8.00 \*8\* Cust Item ID:  
 Required Date: 10/04/13 Req'd Qty: 8.00 \*8\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 SMD B 11.04				10			
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				10	13-11-5		
170 *170* QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00				10x		13/11/05	DAS 36 9-89



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Item ID: D4434-047 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Cover Assembly  
 Start Date: 9/27/13 Start Qty: 8.00 \*8\* Cust Item ID:  
 Required Date: 10/04/13 Req'd Qty: 8.00 \*8\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
*180*						10x			U/11/05 DAS 36 9-89
Small Fab	Memo	0.00							
Small Fab	Install rivet as per dwg								
185	QC5- Inspect part completeness to step on W/O	0.00				10			
*185*									
QC	Memo	0.00							
Quality Control									
186	Black Sandtex(Ref 4.3.5.7) per QSI005 4.3	0.00				10	φ	13-11-8	DAS 34 9-89
*186*									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7:00 OVEN TEMPERATURE: 320° FINISH TIME: 7:30								

# Work Order ID 107530

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Item ID: D4434-047 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Cover Assembly  
 Start Date: 9/27/13 Start Qty: 8.00 \*8\* Cust Item ID:  
 Required Date: 10/04/13 Req'd Qty: 8.00 \*8\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
187	QC3- Inspect Part Finish	0.00							
*187*						10			
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location	0.00							
*190*						10x			
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
*200*									
QC	Memo	0.00							
Quality Control									

13-11-11  
 MK  
 13-11-11

# Picklist Print

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Page 1

Work Order ID: 107530

Parent Item: D4434-047

Parent Item Name: Cover Assembly

Start Date: 9/27/13

Required Date: 10/04/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB 11.12.22 per PA5  
EC verified by:JLM IPP RevC 12.01.24 PER DWG REV.A DD VERF:EC  
IPP RevD 12.03.05 per REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	452.0760	0.5789	<del>4.8749474</del>			
------------------------------------	--	-----------	----	--	--	-----	----	----------	--------	----------------------	--	--	--

Location	Loc Qty	Loc Code
MAT021	452.076	
m126350	260.076	
m126981	192	

126350 → 5.9

MS20470AD4-3 Rivet - Universal Head		Purchased	No			185	Each	5,825.0000	2	16			
--	--	-----------	----	--	--	-----	------	------------	---	----	--	--	--

Location	Loc Qty	Loc Code
GA	1649	
1642	157	
2193	1492	
ST335	4176	
2193	4176	

20

13/11/05  
DAS  
36  
9-89

DART AEROSPACE LTD		Work Order:	107530
Description: COVER Assembly		Part Number:	D4434-047
Inspection Dwg: 4434 Rev: 3		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.098	-		V	Ukm-01
.35	+/- .030	.35	-		V	
.65	+/- .030	.65	-		V	
.85	+/- .030	.85	-		V	
1.75	+/- .030	1.75	-		V	
2.65	+/- .030	2.65	-		V	
2.80	+/- .030	2.80	-		V	
2.95	+/- .030	2.95	-		V	
5.40	+/- .030	5.40	-		V	
5.53	+/- .030	5.53	-		V	
5.70	+/- .030	5.70	-		V	
5.82	+/- .030	5.82	-		V	
6.10	+/- .030	6.10	-		V	
6.13	+/- .030	6.13	-		V	
2.34	+/- .030	2.34	-		V	
2.65	+/- .030	2.65	-		V	
3.02	+/- .030	3.02	-		V	
3.04	+/- .030	3.04	-		V	
.60	+/- .030	.60	-		V	
11.22	+/- .030	11.22	-		T	
11.24	+/- .030	11.24	-		T	
11.59	+/- .030	11.59	-		T	
11.94	+/- .030	11.94	-		T	

Measured by: <i>AK</i>	Audited by: <i>DAS</i> 27 9-89	Preliminary Approval:
Date: 13.09.28	Date: 13.9.50	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*10.04.15*





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 107530
<b>Description:</b> Cover Assembly		<b>Part Number:</b> D4434-047
<b>Inspection Dwg:</b> 4434 <b>Rev:</b> B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

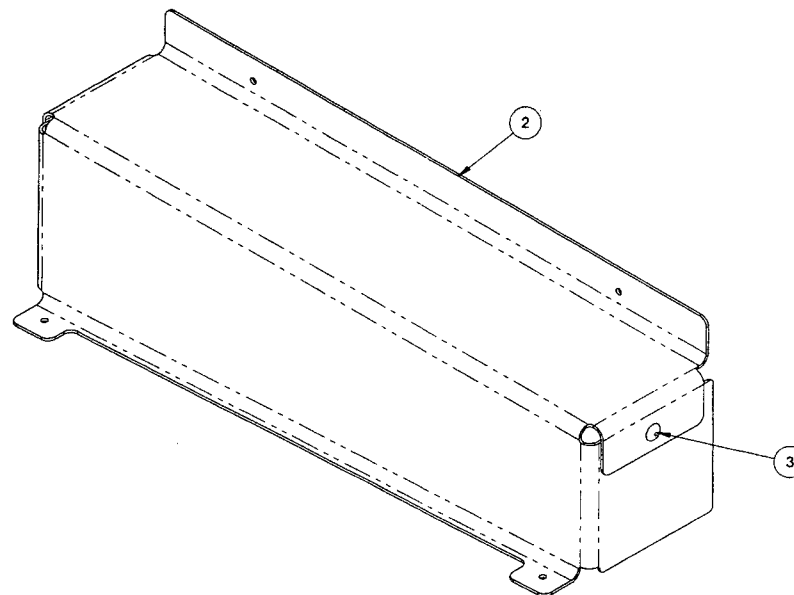
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.68	+1- .030	5.68	-		✓	JKm-01
5.64	+1- .030	5.64	-		✓	
5.36	+1- .030	5.36	-		✓	
5.28	+1- .030	5.28	-		✓	
5.02	+1- .030	5.02	-		✓	
1.42	+1- .030	1.42	-		✓	
1.70	+1- .030	1.70	-		✓	
2.12	+1- .030	2.12	-		✓	
2.24	+1- .030	2.24	-		✓	
2.31	+1- .030	2.31	-		✓	
3.81	+1- .030	3.81	-		✓	
10.41	+1- .030	10.41	-		T	JKm-06
11.91	+1- .030	11.91	-		T	
11.98	+1- .030	11.98	-		T	
12.10	+1- .030	12.10	-		T	
12.52	+1- .030	12.52	-		T	
12.80	+1- .030	12.80	-		T	
14.22	+1- .030	14.22	-		T	
.040	+1- .010	.037	-		✓	

<b>Measured by:</b> <i>AK</i>	<b>Audited by:</b> <i>DAS</i> 27 9-80	<b>Preliminary Approval:</b>
<b>Date:</b> 13.09.28	<b>Date:</b> 13.09.30	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*10.04.15*

ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D4434-047	COVER ASSEMBLY
2	1	D4434-7	BRACKET
3	2	MS20470AD4-3	RIVET



107530MLS  
1309-27

**D4434-047 COVER ASSEMBLY**

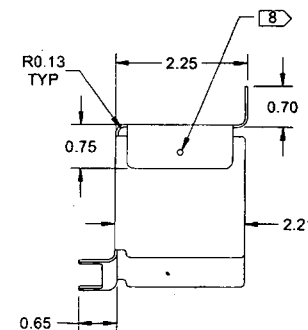
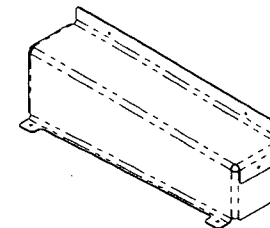
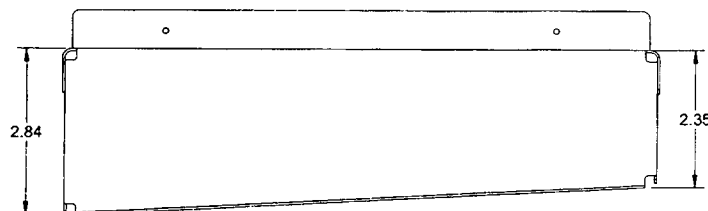
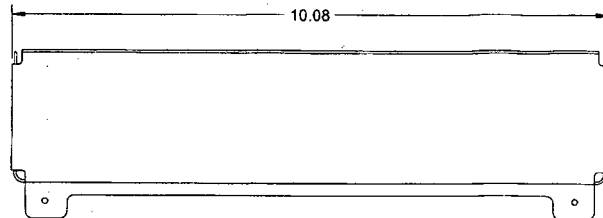
RELEASED  
2012-03-02  
NW

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.263 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>142</i>	DRAWING NO. <b>D4434</b>	REV. B
MFG. APPR.	<i>E</i>	SHEET 5 OF 15	
APPROVED	<i>142</i>	TITLE	SCALE
DE APPR.	<i>142</i>	<b>COVER ASSEMBLY</b>	NTS
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**D4434-7 BRACKET**

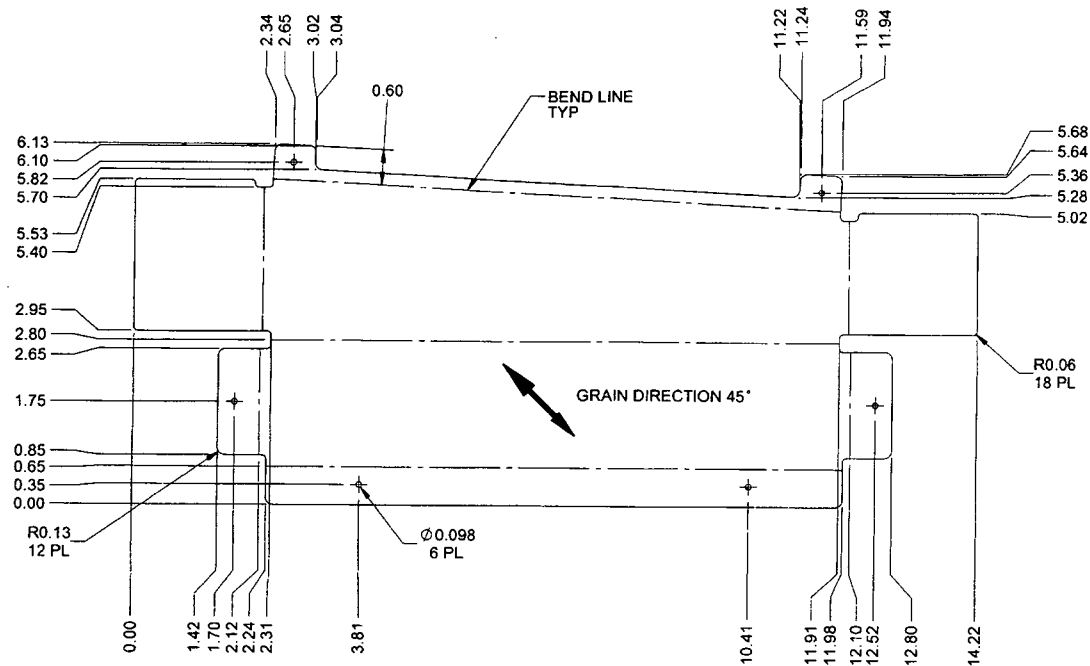
RELEASED  
2012-03-02

**NOTES:**

- 1) MATERIAL: MAKE FROM D4434-7F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs
- 8) TRANSFER  $\varnothing 0.129$  HOLE THRU 2 PLACES

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	<b>D4434</b>	SHEET 12 OF 15
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>COVER ASSEMBLY</b>	NTS
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**D4434-7F FLAT PATTERN**

**RELEASED**  
2012-03-08  
JW

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MD</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BE</i>	<b>D4434</b>	SHEET 13 OF 15
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	<b>COVER ASSEMBLY</b>	NTS
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